Gate:

Thursday, 15/01/2009 11:13:14 AM

User: Julie Dawson

Process Sheet

Customer Job Number : CU-DAR001 Dart Helicopters Services

S.O. No. :

: 44776

Estimate Number

: 11229

P.O. Number

Prsht Rev.

First Issue

Previous Run

This Issue

: 15/01/2009

: NC

: //

: 41425

Type

: SMALL /MED FAB

Part Number

Drawing Name

: D23691

: N/A

: A

Drawing Number

: D2369 REV A

: BRACKET LOCATOR

Project Number

Drawing Revision

Material **Due Date**

JLM

: 30/01/2009

Qty:

6 Um:

Each

Checked & Approved By

Comment

Written By

: Est Rev A

Removed from 9 Digit

05-12-05

Est Rev:B

now water jet

07-12-11 DD

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

M5052H32S040

5052-H32 .040 Sheet

Comment: Qty.:

8.5302 sf(s) 1.4217 sf(s)/Unit Total:

Material: 5052-H34 or H32 0.040" thick

(M5052H32S.040)

Batch: 1/9 057

2.0

3.0

WATER JET

FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D2369 Dwg Rev:___A__

Prog Rev: 1

189-2-9

2-Deburr if necessary

QC2



INSPECT PARTS AS THEY COME OFF MACHINE



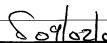
PR 9-3-9

Comment: INSPECT PARTS AS THEY COME OFF MACHINE



Comment: SECOND CHECK

SECOND CHECK





PACKAGING 1

PACKAGING RESOURCE #*



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:



Dart Aerospa	ace Ltd
--------------	---------

										
W/O:			W	ORK ORDER CHANG	ES					
DATE	STEP	PRO	OCEDURE CH	ANGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
•										
Part No		PAR #:	Fault Cat	egory:	_ NCR: Yes	No DQA:	Date: _			
	Res	solution:	Dispositi	on:	_ QA: N/C C	losed:	Date: _			
NCR:		,	WORK ORE	DER NON-CONFORMA	ANCE (NCF	₹)				
DATE	Description of NC		Description of NC Corrective Action			Verification	1 Approval	Approval		
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign and Date	Section C	gn & Section C	Date Section C	Chief Eng	QC Inspector
							:			
				e Berlineller						

NOTE: Date & initial all entries

Date:

Thursday, 15/01/2009 11:13:15 AM

User:

Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET LOCATOR

Job Number: 44776

Part Number: D23691

Job Number:



Seq. #:

Machine Or Operation:

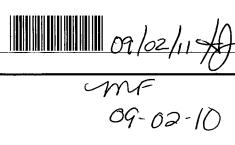
Description:

6.0

QC21



FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



Dart Aerospace Ltd

W/O: WORK ORDER CHANGES							
DATE	DATE STEP PROCEDURE CHANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
į							
					,		

Part No:		PAR #:	Fault Category:	NCR: Yes No [DQA:	Date:	
	Resolution:		Disposition:	QA: N/C Closed:		Date:	

NCR:			WORK ORD	ER NON-CONFORMANC	E (NCR)			
		Description of NC	Corrective Action Section B				Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	- Verification Section C	Chief Eng	QC Inspecto
								<u> </u>

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	N4776
Description: Deck Plate Locator Bracket	Part Number:	D2369-1
Inspection Dwg: D2369 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.500	+/-0.010	,501	×		, -	
4.500	+/-0.010	4,506	b			
1.000	+/-0.010	,998	V			
5.709	+/-0.010	5,707	¥			
37.996	+/-0.010	37.996	X			
38.297	+/-0.010	38.397	¥			
5.000	+/-0.010	4.998	8			
4.451	+/-0.010	4,460	Y			
0.549	+/-0.010	,553	y			
Ø0.191	+0.005/-0.000	194	*			
Ø0.128	+0.005/-0.000	.137	Y			
39.000	+/-0.010	39.000	V			
38.544	+/-0.010	3.8,544				
		-				

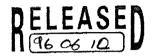
Measured by: B	Audited by:	Prototype Approval: N/A
Date: 9-2-9	Date: 09/102/19	Date: N/A

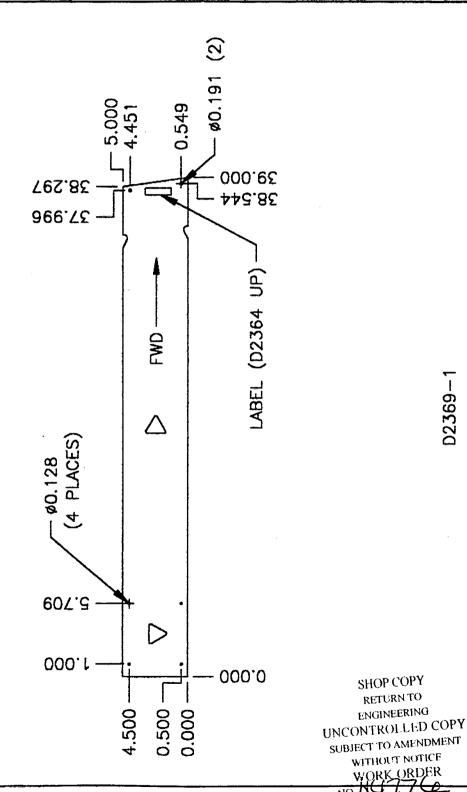
Rev	Date	Change		Revised by Approyed	
Α	04.06.25	New Issue	P/O D350-616-015	KJ/JLM A	
					_





DESIGN B WILLIAMS	drawn by B. Williams	DART VICTORIA	AEROS International				
	APPROVED	DRAWING NO.				REV.	A
800	4	D2369			SHEET	1 OF	2
DATE	7	TILE				SCA	ΙĒ
95:02:20		DECK PLATE I	LOCATOR	BRACKE	T	1	1:7





MATERIAL: 5052-H34 0.040 THICK

D2369-1

Copyright 1995 by DART AEROSPACE LTD





DESIGN	DRAWN BY	DART AEROSPAC	E LTD
B WILLIAMS	B WILLIAMS	VICTORIA INTERNATIONAL AIRPO	RT, CANADA
CHECKED	APPROVED	DRAWING NO.	REV. A
Sw	1	D2369	SHEET 2 OF 2
DATE	7	TITLE	SCALE
95:02:20		DECK PLATE LOCATOR BRAC	KETS 1:7

RELEASED 96 06 10

